

Date: Thursday, 2/9/2006 1:49:23 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARPAW KIT (19"X24")
Job Number :	25767		
Estimate Number :	10323		
P.O. Number :	N/A	Part Number :	K10008
This Issue :	2/9/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2432 REV F3
First Issue :	N/A	Project Number :	N/A
Previous Run :	25584	Drawing Revision :	F3
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	2/25/2006
Written By :	<i>See Comment Below</i>		Qty: 10 Um: Each
Checked & Approved By :	<i>06.02.10</i>		
Comment :	Est Rev:J 04.02.17 Blank size changed KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D315-670-011

D427-659-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

KS 06-02-23 10

2.0

MUHMBW10

UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total: 68.2500 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMBW10)

Batch: *M100417*

End 06/03/24 10

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

End 06/03/24 10
JF. 06/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:49:24 PM
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Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/03/26 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.03.26 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4166 f(s)/Unit Total: 4.1660 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
6 D2182B050 Rubber Cushion B24870

m.f.

(19)

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
12 D2274 Radius Block B25769
2 D2432F(ref only) Bearpaw 25167

(10)

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
6 D2438 Clamp B25015

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25767

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B25372

M.F. 06.03.27

(10)

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 Each(s)/Unit Total : 4.1660 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B04182

M.F. 06.03.27

(10)

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19085

M.F. 06.03.27

(10)

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M15432

M.F. 06.03.27

(10)

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M19085

M.F. 06.03.27

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/03/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 ✓ Nut (or -4) m19099 m.F. 06.03.27

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/03/27 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: B REVE

06/03/27 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/27 (10)

Job Completion



06/03/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25767
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055	—			
B	5.500	+/-0.030	5.499	—			
C	0.200	+/-0.030	0.199	—			
D	0.25 x 45°	+/-0.030	0.247	—			
E	R0.250	+/-0.030	R0.250	—			
F	0.250	+/-0.010	0.253	—			
G	0.625	+/-0.030	0.635	—			
H	0.375	+/-0.010	0.383	—			
I	0.950	+0.030/0.010	0.951	—			
J	19.000	+/-0.030	19.000	—			
K	3.14	+/-0.030	3.140	—			
L	3.28	+/-0.030	3.278	—			
M	Ø0.260	+0.005/-0.000	Ø0.260	—			
N	Ø0.93	+/-0.030	Ø0.930	—			
O	0.30	+0.030/-0.000	0.324	—			
P	23.750	+/-0.030	23.750	—			
Q	7.375	+/-0.030	7.375	—			
R	4.250	+/-0.010	4.250	—			
S	2.000	+/-0.030	2.000	—			
T	9.000	+/-0.010	9.000	—			
U	9.000	+/-0.010	9.000	—			
V	0.375	+/-0.010	0.381	—			

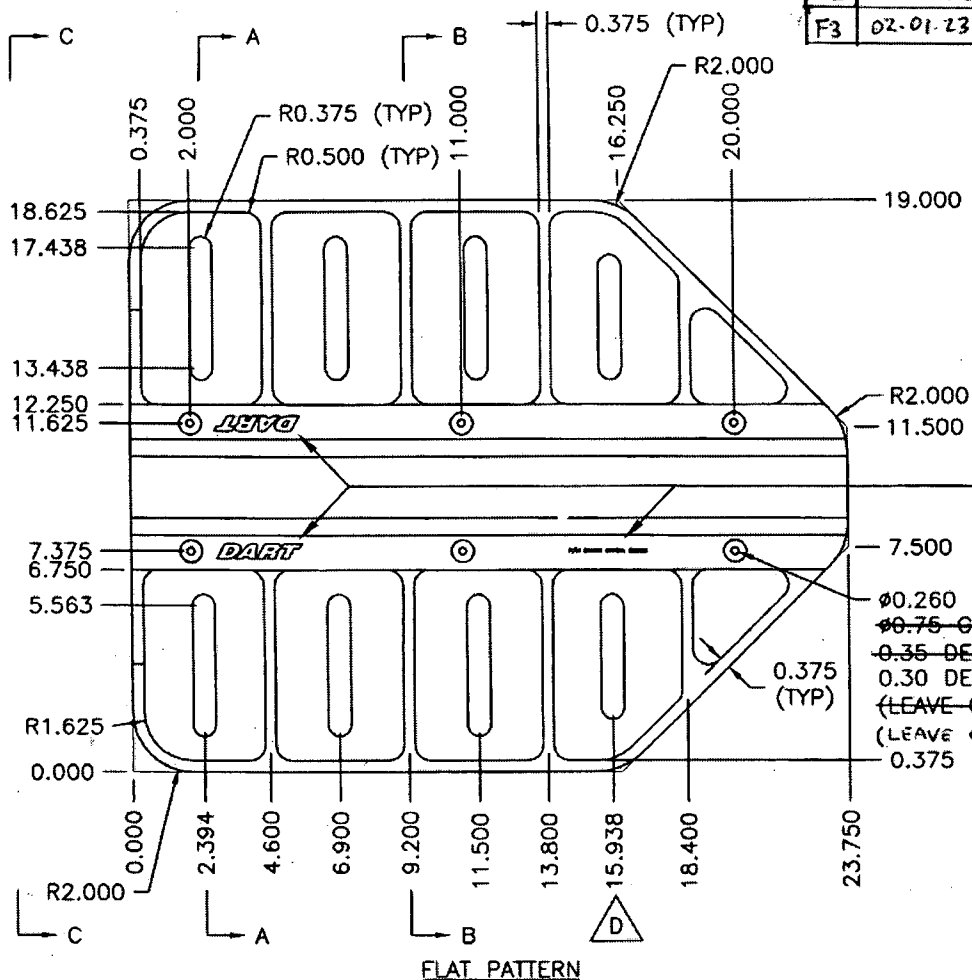
Measured by:	gml	Audited by:	En	Prototype Approval:	N/A
Date:	06/03/24	Date:	06/03/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 08-22-2011 BY 60322 UCBAW

RELEASED
98-06-17 K8

F1	99.03.03	ADD DEC 9143
F2	01.03.28	$\phi 0.93$ WAS $\phi 0.75$ RF
F3	02.01.23	CLARIFY CORE DIMS RF







ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F	SHEET 1 OF 2	
DATE 98.05.12		TITLE BEARPAW	SCALE 1:6		
A	95.10.31	NEW ISSUE			
B	96.01.24	RE-DESIGN			
C	96.03.26	CHANGE BORE AND C'BORE DEPTH			
D	96.06.04	MOVE SLOT			
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS			
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N			

EFFECTIVE DEOS

9143

(YP) 
 BORE Ø 0.43 C' BORE
 2" FROM TOP (MIN.) 
 2" FROM BOTTOM
 300 MIN.) 
 650 MIN.)


D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25767



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE

